

**WHAT IS CLAIMED AS NEW AND DESIRED TO BE SECURED BY LETTERS PATENT
OF THE UNITED STATES IS:**

1. A photoreceptor comprising:
an electroconductive substrate;

5 a charge generation layer located overlying the
electroconductive substrate optionally with an intermediate
layer therebetween; and

a charge transport layer formed overlying the charge
generation layer using a non-halogenated solvent and comprising
10 a charge transport material and a resin,

wherein the charge generation layer comprises a polyvinyl
acetal resin and a charge generation material having an average
particle diameter less than a roughness of a surface of either
the electroconductive substrate or the intermediate layer, on
15 which the charge generation layer is located.

2. The photoreceptor according to Claim 1, wherein the
average particle diameter of the charge generation material is
not greater than 0.3 μm and not greater than 2/3 of the roughness
20 of the surface of either the electroconductive substrate or the
intermediate layer.

3. The photoreceptor according to Claim 1, wherein the
charge generation material is a titanyl phthalocyanine.
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4. The photoreceptor according to Claim 3, wherein the
titanyl phthalocyanine has an X-ray diffraction spectrum in

which a maximum peak is observed at a Bragg (2θ) angle of $27.2^\circ \pm 0.2^\circ$ when a Cu-K α X-ray having a wavelength of 1.542 Å is used.

5 5. The photoreceptor according to Claim 4, wherein the titanyl phthalocyanine further has a lowest angle peak at an angle of $7.3^\circ \pm 0.2^\circ$, and wherein an interval between the lowest angle peak to a next peak at a high angle side is not less than 2.0°.

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6. The photoreceptor according to Claim 5, wherein the titanyl phthalocyanine has no peak at an angle of 26.3° .

7. The photoreceptor according to Claim 3, wherein the
15 charge generation layer is formed by coating a coating liquid comprising a dispersion which is prepared by dispersing the titanyl phthalocyanine so as to have a particle diameter distribution such that an average particle diameter is not greater than 0.3 µm and a standard deviation is not greater than
20 0.2 µm and then filtering the dispersed titanyl phthalocyanine liquid with a filter having an effective pore size not greater than 3 µm.

8. The photoreceptor according to Claim 3, wherein the
25 titanyl phthalocyanine in the charge generation layer is prepared by subjecting a titanyl phthalocyanine which has either an irregular form or a low crystallinity and has a primary

particle diameter not greater than 0.1 μm and which has an X-ray diffraction spectrum in which a maximum peak having a half width not less than 1° is observed at a Bragg (2θ) angle of from 7.0° to 7.5° ($\pm 0.2^\circ$) when a Cu-K α X-ray having a wavelength of 1.542 Å is used, to a crystal conversion treatment using an organic solvent in the presence of water to form a crystal-changed titanyl phthalocyanine, and then subjecting the crystal-changed titanyl phthalocyanine to a filtering treatment before the crystal-changed titanyl phthalocyanine has an average primary particle diameter not less than 0.3 μm .

9. The photoreceptor according to Claim 1, wherein the charge transport layer further comprises a polycarbonate resin having at least a triaryl amine structure in at least one of a main chain and a side chain.

10. The photoreceptor according to Claim 1, further comprising:
a protective layer located overlying the charge transport layer.

11. The photoreceptor according to Claim 10, wherein the protective layer comprises an inorganic pigment having a resistivity not less than $1 \times 10^{10} \Omega \cdot \text{cm}$.

12. The photoreceptor according to Claim 11, wherein the inorganic pigment is a material selected from a group consisting

of alumina, titanium oxide and silica.

13. The photoreceptor according to Claim 12, wherein the inorganic pigment is α -alumina.

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14. The photoreceptor according to Claim 10, wherein the protective layer comprises a charge transport polymer.

15. The photoreceptor according to Claim 1, wherein a surface of the electroconductive substrate is subjected to an anodic oxidation treatment.

16. The photoreceptor according to Claim 1, wherein the non-halogenated solvent is a solvent selected from the group consisting of cyclic ethers and aromatic hydrocarbons.

17. An image forming apparatus comprising:
at least one image forming unit comprising:
an image bearing member;
a charger configured to charge the image bearing member;
a light irradiator configured to irradiate the image bearing member with light to form an electrostatic latent image on the image bearing member;
an image developer configured to develop the electrostatic latent image with a developer comprising a toner to form a toner image on the image bearing member; and

a transfer device configured to transfer the toner image onto a receiving material,

wherein the image bearing member is the photoreceptor of according to Claim 1.

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18. The image forming apparatus according to Claim 17, comprising plural image forming units.

19. The image forming apparatus according to Claim 17,
10 wherein the light irradiator comprises at least one of a light emitting diode and a laser diode.

20. The image forming apparatus according to Claim 17,
wherein the charger is either a contact charger or a proximity
15 charger which comprises a charging member charging the image bearing member while a gap is formed between the charging member and the image bearing member.

21. The image forming apparatus according to Claim 20,
20 the charger being a proximity charger, wherein the gap is not greater than 200 μm .

22. The image forming apparatus according to Claim 20,
wherein the charging member applies a DC voltage overlapped with
25 an AC voltage.

23. A process cartridge comprising:

the photoreceptor according to Claim 1; and
at least one of a charger configured to charge the
photoreceptor, a light irradiator configured to irradiate the
photoreceptor with light to form an electrostatic latent image
5 on the photoreceptor, and an image developer configured to
develop the electrostatic latent image with a developer
comprising a toner to form a toner image on the photoreceptor.

24. A method for manufacturing a photoreceptor
10 comprising:
preparing a charge generation layer coating liquid
comprising a dispersion of a titanyl phthalocyanine having a
particle diameter distribution such that an average particle
diameter is not greater than 0.3 μm and a standard deviation
15 is not greater than 0.2 μm and a polyvinyl acetal;
filtering the charge generation layer coating liquid with
a filter having an effective pore size not greater than 3 μm ;
coating the charge generation layer coating liquid
overlying an electroconductive substrate optionally with an
20 intermediate layer therebetween to form a charge generation
layer thereon; and
coating a charge transport layer coating liquid
comprising a charge transport material, a resin and a non-
halogenated solvent on the charge generation layer to form a
25 charge transport layer thereon,
wherein the charge generation material has an average
particle diameter less than a roughness of a surface of either

the electroconductive substrate or the intermediate layer, on which the charge generation layer is located.

25. The method according to Claim 24, wherein the charge
5 generation layer coating liquid preparing step comprises:

subjecting a titanyl phthalocyanine which has either an irregular form or a low crystallinity and has a primary particle diameter not greater than 0.1 μm and which has an X-ray diffraction spectrum in which a maximum peak having a half width
10 not less than 1° is observed at a Bragg (2θ) angle of from 7.0° to 7.5° ($\pm 0.2^\circ$) when a Cu-K α X-ray having a wavelength of 1.542 Å is used, to a crystal conversion treatment using an organic solvent in the presence of water to form a crystal-changed titanyl phthalocyanine;

15 then subjecting the crystal-changed titanyl phthalocyanine to a filtering treatment before the crystal-changed titanyl phthalocyanine has an average primary particle diameter not less than 0.3 μm ; and

preparing a charge generation layer coating liquid
20 comprising the crystal-changed titanyl phthalocyanine having a particle diameter distribution such that an average particle diameter is not greater than 0.3 μm and a standard deviation is not greater than 0.2 μm and a polyvinyl acetal.

25 26. The method according to Claim 24, wherein the non-halogenated solvent is a solvent selected from the group consisting of cyclic ethers and aromatic hydrocarbons.